

Work Order ID 56057

February 9, 2010 1:24:57 PM



Page 1

Item ID: D2332-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Lid Prop Assembly 6.69" long

Start Date: 2/09/10 Start Qty: 6.00



Cust Item ID:

Required Date: 2/15/10 Req'd Qty: 6.00

Customer:

Reference:

Approvals:

Process Plan:

*ML*Date: *10-2-09*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2332

Rev C1

100

0.00



Small Fab

Small Fab

Memo

0.00

1- Cut D2332-7 and D2332-5 to length as per dwg D2332.

2- Cut D2332-11 using 1/2" S.S tubing 7.735" long.

3- Deburr.

*=> m.k**10/02/24**(6X)*

110

0.00



Brake NC

Brake NC

Memo

0.00

Punch and form D2332-11 to length as per dwg D2332 using DT8012
(need 2 per ass'y)*=> m.k**10/02/24**(6X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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120

0.00



Small Fab

Memo

0.00

Small Fab

1- Drill hole in D2332-11 as per dwg D2332 using drill jig DT8459
(drill one per ass'y)

2- Ensure no foreign objects inside tube

3- Deburr

=> m, k 10/02/24
=> m, k 10/03/03 (1X)

130

0.00



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

D2332-5 - E x6
D2332-7 - E x6
D2332-11 - E x6
D2332-13 - E x6

(x6)
8/10/25

140

0.00



Large Fab

Memo

0.00

Large Fab

Weld D2332-11 and D2332-5 as per dwg (weld 1 per ass'y)
*****ensure nothing is inside of tube before welding*****

S.S Rod batch: M108160

EL 10-3-2
P/L 10-03-03 -> (1)

(x6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

⑥

PD 10.03.02

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S w / o s l o s

⑥

PD →

170

0.00



Small Fab

Memo

0.00

Small Fab

1- Tumble

2- Assemble as per dwg D2332

9/3/10/03/04 ⑥

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: _____ Fault Category: Large Fabs NCR: Yes No DQA: _____ Date: 10-03-16
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: Yes Date: 10/03/16

NCR: <u>56057</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
<u>10/03/16</u>	<u>160</u>	Found During inspection that qty 41 part has a Foreign object in it AFTER welding. R.L. Process.	<u>[Signature]</u>	<u>Scrap + Destroy Qty x1</u> <u>Replac D2332-11 m 112800</u> <u>Replac D2332-5 m 107387</u>	<u>m-h</u> <u>10/03/16</u> <u>m-h</u> <u>10/03/16</u>	<u>S</u> <u>10/03/16</u>	<u>[Signature]</u>	<u>S</u> <u>10/03/16</u>
			<u>[Signature]</u>	<u>Reweld per QSL004. Ensure</u> <u>no Foreign objects are in tube</u> <u>before welding</u> <u>QCA</u>	<u>[Signature]</u> <u>10-03-03</u> <u>PD 10-03-03</u>	<u>S</u> <u>10/03/16</u>	<u>[Signature]</u>	<u>S</u> <u>10/03/16</u>

NOTE: Date & initial all entries

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Required Date: 2/15/10 Req'd Qty: 6.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S. S. S.

8/6/03/04

*66**66*

190

Identify as per dwg & Stock Location: *S10*

0.00



Packaging

Memo

0.00

Packaging

*10-3-3**SP*

200

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

*10/03/11**MF**10-3-5*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 1

Work Order ID: 56057

Parent Item: D2332-041

Parent Item Name: Lid Prop Assembly 6.69" long

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Date: 2/09/10

Required Date: 2/15/10

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304R.250		Purchased	No			100	f	23.4328	0.6316			
304 SS Round bar .250												

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

23.4328

107387

23.4328

M304TR1.000W.049

Purchased

No

100

f

56.1143

2.7158



304 RD Tube 1.00 x .049W

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

56.1143

108756

14.92

111457

41.1943

M304TR0.500W.035

Purchased

No

110

f

179.4969

7.8947



304 RD Tube .500 x .035W

Warehouse Loc Qty Loc Code
Location

Main Warehouse

MAT

179.4968674

108250

2.23

111704

31.6682737

112187

43.9830937

112800

101.6155

m.k
0.6316 10/02/24

m.k
2.7158 10/02/24

*
m.k
1,3157 10/02/24
2X 6.5789 7.24
10X

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 56057



Parent Item: D2332-041



Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 2/09/10

Required Date: 2/15/10

Comments: IPP: B02.08.12 Re-format; Incorporated D2332-13/-11/-7/-5 KJ/RF
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

AN4-4A

Purchased

No

170

Each

115.0000

6.0000



Bolt



9510/03/04

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

115

101291

3

106918

1

108138

54

111295

57

6

AN960JD416L

Purchased

No

170

Each

745.0000

18.0000



Washer



9510/03/04

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

745

105078

4

107008

54

108583

38

110153

249

112492

400

QSI017
NAS1149D0416J
M10538 (18x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

February 9, 2010 1:25:01 PM

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Parent Item Name: Lid Prop Assembly 6.69" long

Start Date: 2/09/10

Required Date: 2/15/10

Comments: IPP: B□02.08.12□Re-format; Incorporated D2332-13/-11/-7/-5□KJ/RF□
IPP Rev:C 08-06-02 add comment DD verified by:EC

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21042L4		Purchased	No			170	Each	2,555.000	6.0000			



Nut



Handwritten signature and date: 2/10/03/04

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

ST

2555

102552

6

104248

6

110507

184

111827

1359

113422

1000

15924

0

6

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

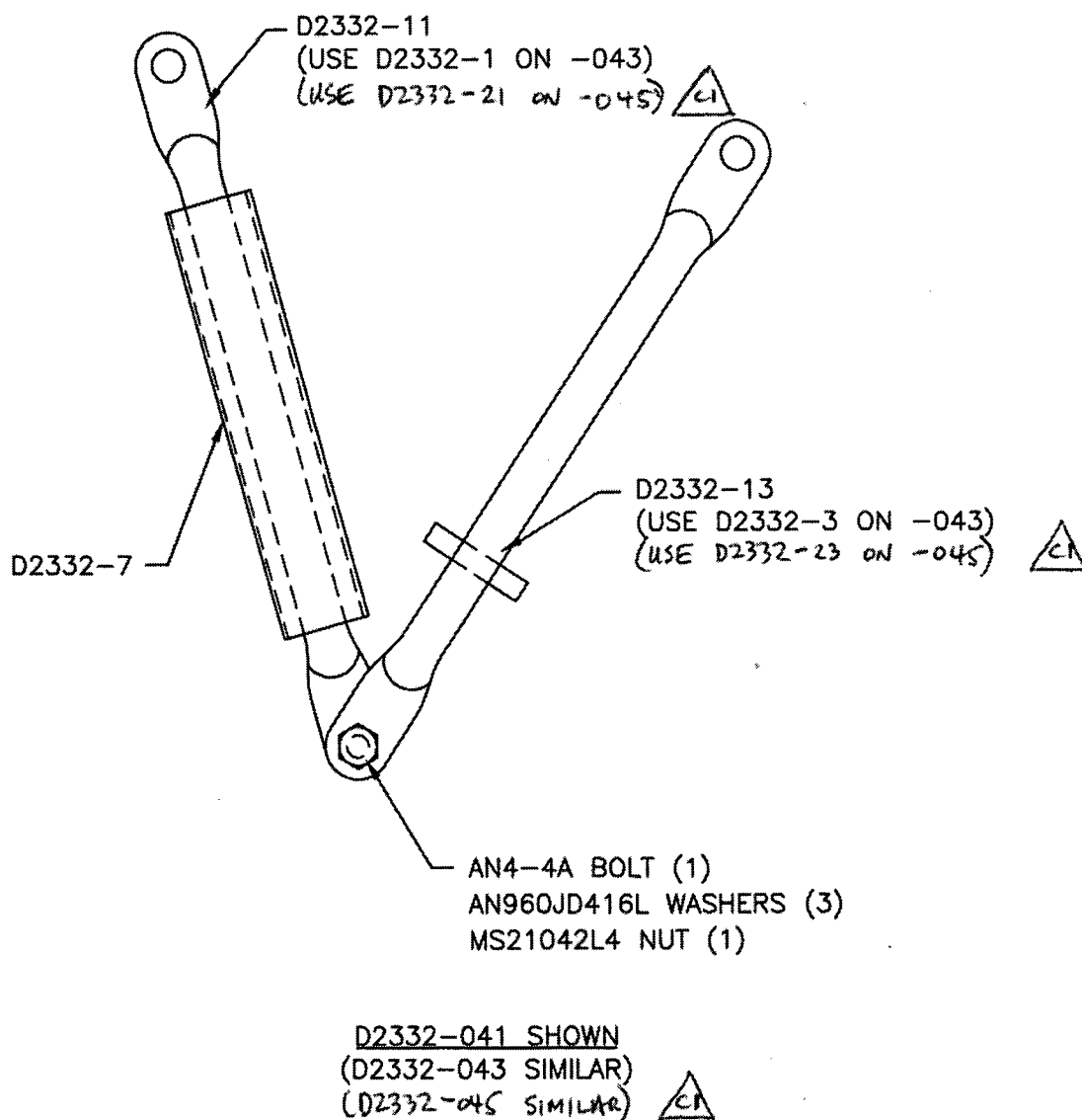
NOTE: Date & initial all entries



w/o 56037

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO. D2332	REV. C SHEET 1 OF 2
DATE 03.07.03		TITLE LOD PROP ASSEMBLY	SCALE NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04



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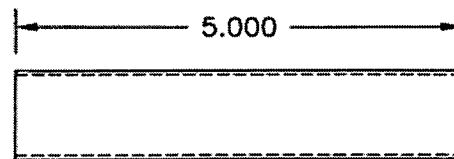
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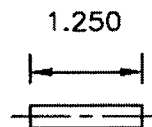
ISSUED TO

DESIGN	DRAWN BY	DART AEROSPACE LTD
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA
DATE 03.07.03	DRAWING NO. D2332	REV. C
	TITLE LID PROP ASSEMBLY	SHEET 2 OF 2
		SCALE 1:2
C	03.07.03	MAKE - 041 PROP 6.69" LONG (STD)
C1	03.08.06	MAKE - 043 PROP 8.00" LONG (LFT)
		ADD - 045 PROP 7.25" LONG

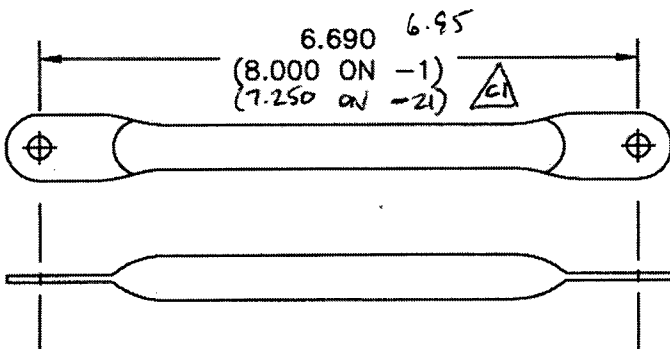
info 54051



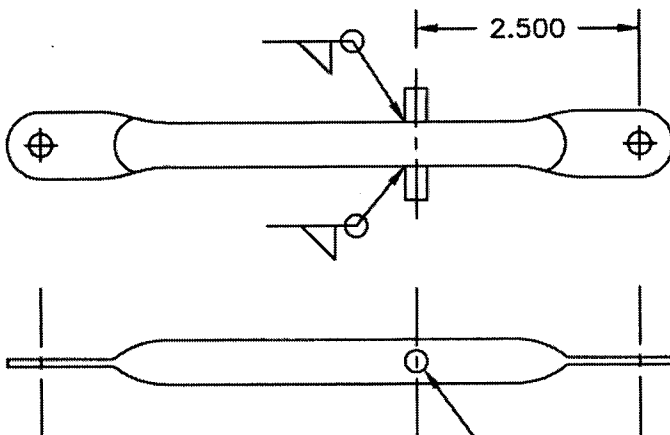
D2332-7 LOCKING COLLAR



D2332-5 STOP PIN



D2332-11 PROP
(D2332-1 SIMILAR)



D2332-13
M/F D2332-11 & D2332-5

(D2332-3 SIMILAR - M/F D2332-1 & D2332-5)
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



DRILL 1/4 HOLE FOR D2332-5

NOTES:

- MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
- TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

RELEASED
03.07.04